

Work Order ID 70582

Monday, June 13, 2011 10:27:01 AM



Page 1

Item ID: D3027-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 6/10/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 6-16-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3027

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3027

NOTE GRAIN DIRECTION**

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-6-23

(30)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70582

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Start Date: 6/10/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sub 11/23

counted
+30

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Deburr if necessary

Form as per Dwg D3027

SB 11/27

30

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 11/27

counted
+30

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Page 3

Item ID: D3027-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 6/10/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				30		11-6-27	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				30	0	11/06/27	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>031</u> Memo	0.00 0.00				30		11/06/27	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 70582

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Page 4

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Item Name: Clip

Start Date: 6/10/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 J

11-0628

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 10:27:08 AM

Page 1

Work Order ID: 70582



Parent Item: D3027-7



Parent Item Name: Clip

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C05.10.07 Added forming step and Issue P/O KJ/JLM
IPP Rev:B Now on WaterJet 08-12-08 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

Purchased

No

100

sf

122.3000

0.024

0.303158

1



B11-6-23

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

122.3

117684

122.3

117684

30

W/O:		WORK ORDER CHANGES					
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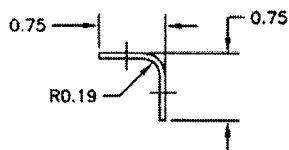
NOTE: Date & initial all entries



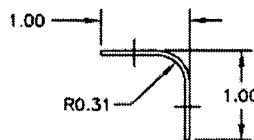
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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3027
				REV. B SHEET 1 OF 2
DATE	05.09.20	TITLE	CLIP	SCALE 1:2
A	01.05.18	NEW ISSUE		
B	05.09.20	REMOVE HOLES FROM -7		

RELEASED

05.10.03 *[Signature]*



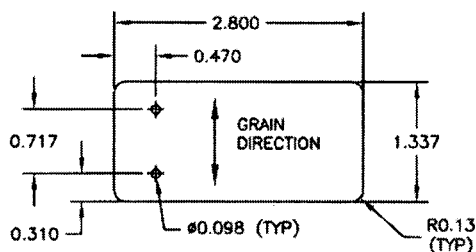
D3027-1 BEND DETAIL



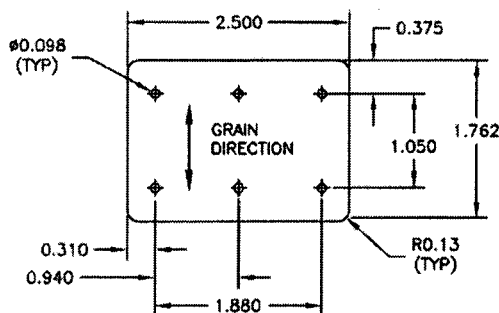
D3027-3 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70582

pl 11 06-12



D3027-1 FLAT PATTERN
(0.063" SHEET)



D3027-3 FLAT PATTERN
(0.050" SHEET)

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

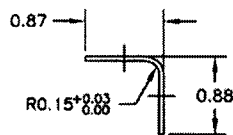
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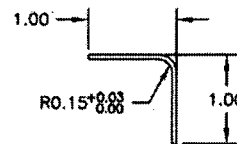
DART

DESIGN RF	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3027	REV. B SHEET 2 OF 2
DATE 05.09.20		TITLE CLIP	SCALE 1:2

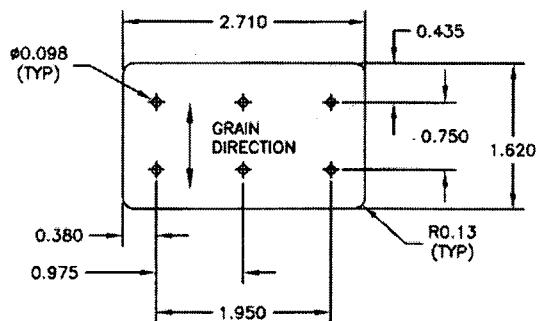
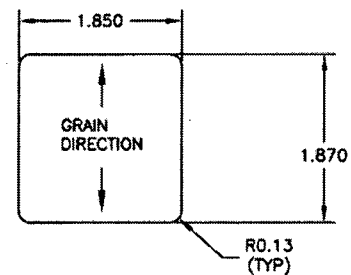
RELEASED

05.10.03 *[Signature]**u/670587*

D3027-5 BEND DETAIL



D3027-7 BEND DETAIL

D3027-5 FLAT PATTERN
(0.050" SHEET)D3027-7 FLAT PATTERN
(0.050" SHEET)

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